

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007750**Date Inspected:** 02-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member were identified as OBG OBW3A. The weld identification numbers are as follows: OBW3A-008, 010. Caltrans QA observed ZPMC welders, 220066 and 220069 performing base metal repairs of weld joint SEG20A-031 located on OBG segment 4BE. ZPMC QC was identified as Wu Zhi Cheng. The welding appeared to be in conformance with WPS-345-FCAW-1G (1F).

Bay 10-

Caltrans QA observed FCAW welding of Fit lugweld joints NSTL3-3 G/K 105, 107 and NSTL3-3 G/F 014, 016 located on the North Tower Lift 3. ZPMC welder was identified as 053116 and 054069. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

SAW welding of weld joint 51A located on NSD1-FBSA4-1 A/C. ZPMC welder was identified as 051413. ZPMC QC is identified as Wang Hao. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-U3C-S-2.

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Bay 11-

Caltrans QA observed FCAW welding of weld joint 016 and 017 located on ESD1-FDSA4-2 D/D. ZPMC welders were identified as 066484 and 070212. ZPMC QC is identified as Zhang Zhi Neng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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